



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6205G19332-3G
Job Sheet 186568



Part No: RBW6205G19332-3G

Job Qty: 4 pcs

Part Name: Main Rotor Scissor Bushing Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB RBW6205G19332-3G Rev 3 IPP Rev A 18.03.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	12/28/18		0.00	0.80	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	12/28/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 38		38
							QC 5 - 42		9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	4 pcs	12/28/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS
							Packaging 3 - 6 - B4B		25

9-89

Date: 01/26/19

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	4 pcs	12/28/18	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op **100** - (Small Fab) Assemble as per DWG. Apply a small amount of Bronze anti-sieze to threads of steel nut.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

Part / Item	Component Name	Quantity	Operation	Container
NTA-916	Thrust Bearing	4 Ea (1 ea)	100-Small Fab - 1	5105371
RBW6205G19332-3G-1	Draw Bolt	4 Ea (1 ea)	100-Small Fab - 1	5097136
RBW6205G19332-3G-3P	CLAMP	8 pcs (2 ea)	100-Small Fab - 1	5029011
RBW6205G19332-3G-5	Receiver	4 pcs (1 ea)	100-Small Fab - 1	5143065
TRA-916	Thrust Washer	8 Ea (2 ea)	100-Small Fab - 1	5105366
90565A333	Nut, Steel	4 Ea (1 ea)	100-Small Fab - 1	5051301

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90565A333	4	42	0
	NTA-916	4	20	0
	RBW6205G19332-3G-1	4	11	0
	RBW6205G19332-3G-3P	8	8	0
	RBW6205G19332-3G-5	4	4	0
	TRA-916	8	40	0

Specifications could not be found.



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Bill of Materials

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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/28/18	0.00	0.67	Start Up Small Fab-4		
100	Small Fab	4 pcs		12/28/18	0.00	0.80	Small Fab-9		
110	QC	4 pcs		12/28/18	0.00	0.00	QC5		
130	Packaging	4 pcs		12/28/18	0.00	0.00	Packaging3-2		
140	QC21-FG	4 Ea		12/28/18	0.00	0.00	QC21		

Part Op 100 - Assemble as per DWG. Apply a small amount of Bronze anti-sieze to threads of steel nut.
Descriptions: 130 - Identify and Stock

Part / Item

NTA-916

RBW6205G19332-3G-1

RBW6205G19332-3G-3

RBW6205G19332-3G-5

TRA-916

90565A333

ration

Container

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Start up Operation

Operation

90-Start up Operation

Required

Inventory

Allocated

10	0
20	0
6	0
0	0
0	0
30	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



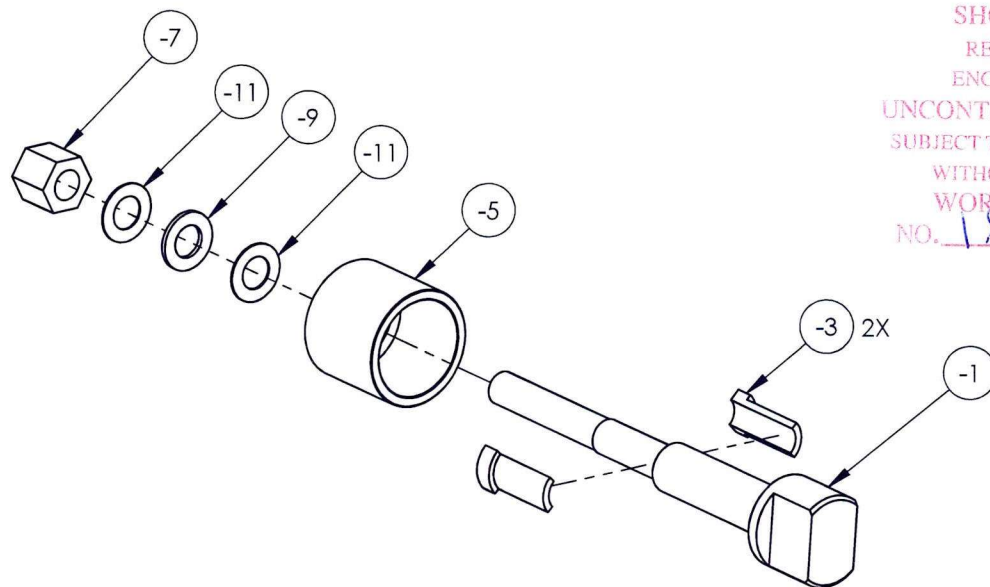
QA Closed: _____ Date: _____

Work Order update only ☐

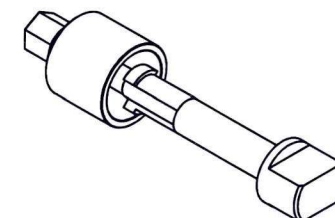
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		BECAUSE OF DIFFERENT ENGRAVINGS CREATED -18 RECEIVER TO REPLACE -07 ON TOOL RBW6205G19432-3G. ADDED ENGRAVING NOTES TO -07 & -18. ADDED -3G TO ALL PART NUMBERS. TO -27 ADDED REF. DIMENSIONS. ON -3 & -17 DRAW BOLTS CHANGED ENGRAVING FROM T/N, S/N, ECT. TO T/N ONLY.	9/21/09	WP	RW
2	15-0103	-1 DELETED ENGRAVE NOTE. -7 DELETED FINISH WAS CLEAR ANODIZE.	5/12/15	RJC	JAG
3	15-0293	-3 CH'D ANGLE WAS 82° IS 90°, ADDED PART MARK FOR PAIRS NOTE.	9/10/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186568 MCT
18-11-19



NOTES:

- ORIGINAL No. TO REF:
RBW6205G19232 KIT No. = 3G6205G19232
RBW6205G19232-1 ASSY = 3G6205G19332
RBW6205G19232-3 = 3G6205G19552
RBW6205G19232-7 = 3G6205G19751
- ALSO SOLD WITH KIT RBW6205G19232-3G.

DART AEROSPACE	
TITLE M/R SCISSOR BUSHING REMOVAL TOOL	
DWG NO. RBW6205G19332-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:3 DATE 7/8/2009 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	DRAW BOLT	4140/4142 Q&T		2
			-3	2	CLAMP	4140/4142 Q&T		3
			-5	1	RECEIVER	6061		4
			-7	1	TALL NUT	BRONZE ALLOY 642		5
		B/O	-9	1	THRUST BEARING		5/64 X Ø9/16 ID X Ø1 OD (APPLID INDUSTRIAL #NTA-916)	1
		B/O	-11	2	THRUST WASHER		1/32 X Ø9/16 ID X Ø1 OD (APPLID INDUSTRIAL #TRA-916)	1